

# Work Order ID 71197

Thursday, June 23, 2011 12:36:20 PM



Page 1

Item ID: D135-751-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube Installation

Start Date: 6/23/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/06/23 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3492	C
D3507	Rev C

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D135-751-011 CHG001

11 07 27 (1)  
J. L. B. 11-7-27

B71197

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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120

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut Aft end as per dwg D3507

2-Debur ends

3-Drill Aft &amp; Fwd Cap holes using DT8678 &amp; DT8901

4-Locate DT8870 &amp; Drill Ground wire hole on top of Tube.

6-Locate DT8870 with #30 cleco in Ground wire hole, then Pilot Drill all X-Bolt holes using #30" drill. \*\*\*\*DO NOT OPEN AFT CAP HOLES\*\*\*\*

7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892. Open holes to 0.297"

9-Open Aft &amp; Fwd Cap holes using .208" drill.

10-Bore out aft end of tube as per Dwg D3507 &amp; Detail "B".

11-Open ground wire hole .297" section E-E

12- Section G-G holes must be laid out manually, open to #30.

13-Debur holes.

1 0 664/07/19

# Dart Aerospace Ltd

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Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulozhy



Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



BB 11/07/19

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

f 8 2211/07/20

**Dart Aerospace Ltd**

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

0.00



Skidtubes

0.00

Skidtubes

Skidtubes

**Memo**1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507.  
and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 &amp; QSI 015

A/R 241 Sike Flex Batch: 112516  
Exp Date: 12/01/15  
start time: 11:30am  
end time: \_\_\_\_\_

Dh. 11/07/20

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C &amp; D-D.

A/R AL ROD Batch: M12860

BE 11/07/21

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&amp;B

8-Deburr Rivet holes.

B 11/07/21

**Dart Aerospace Ltd**

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Required Date: 7/4/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00							 11.07.21
190  Skidtubes Skidtubes	Skidtubes  Memo 1-Rivet D3506-1/-3 as per Dwg D3507.	0.00  0.00							1  11/07/22
200  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							 11.07.22 (1)

**Dart Aerospace Ltd**

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 φ M 11/07/25

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M117745.

Memo

0.00

Powder Coating

START TIME: 10:10 370°  
OVEN TEMPERATURE: 370°  
FINISH TIME: 10:40.

1 φ BL 11-7-25.

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 φ M 11/07/25

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

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260

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1 0 102126

✓ 1- Install Wearplate & Ground Wire inserts as per Dwg D3507.

✓ 1- Inspect for Foreign objects

✓ 2- Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: 1117516  
Exp Date: 15/01

✓ 3- Install Wearplates as per Dwg D3507,

Note: Install (1) Bolt and (1) washer on Ground Wire insert on top of tube

Do not Install Scews where indicated on Dwg (Note #6)

✓ A/R 241 Sika Flex Batch: 1117516  
Exp Date: 15/01

✓ 4- assemble o-ring to plug as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: 1114169

✓ 5- Wing Walk as per Dwg D3507 and QSI 005 4.4

Batch: 1117063

# Dart Aerospace Ltd

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Customer:


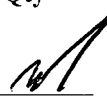



Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00					11	07	26 ⑪
280  Packaging Packaging	Pick Kit  Memo	0.00  0.00					11/7/2011		
290  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00					11	07	27 ⑪

**Dart Aerospace Ltd**

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
300		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D135-751-011								
	Location: _____								
	PPP Rev: <u>B</u>								
310	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

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Parent Item: D135-751-011

Parent Item Name: Skidtube Installation



Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 06-06-21 New Issue JLM  
 IPP Rev:B 06-12-18 As per Rev B JLM  
 IPP Rev:C 07-12-11 ECN 1036 as per revB DD  
 IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC verified DD  
 IPP Rev E 10.02.22 per pAR 09-043 EC verified by: DD IPP Rev:F  
 10.06.09 remove seq110 DD verf:EC IPP Rev G 10.09.17  
 added D3507-1-bent EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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ALS7-1032-130		Purchased		No			Each	1,485.000		38			
Insert													

Location	Loc Qty	Loc Code
ST282	1485	
117717	1485	1118386

x38

D3507-1-BENT		Manufactured		No		120	Each	2.0000	1	1			
Skidtube Assembly EC135													

Location	Loc Qty	Loc Code
LG	2	
62291	1	
62292	1	

B 71200 #1 3E11/07/19

D3504-1		Manufactured		No		170	Each	6.0000	2	2			
Crossbolt Spacer													

Location	Loc Qty	Loc Code
LG001	6	
53742	6	

B 71130 3E11/07/21

**Dart Aerospace Ltd**

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Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3504-3 Manufactured No

170 Each

26.0000

1

1



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

26

31232

6

53743

20

D3504-5 Manufactured No

170 Each

8.0000

2

2



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG001

8

53744

8

D3505-1 Manufactured No

170 Each

0.0000

1

1



Web

D3506-1 Manufactured No

190 Each

47.0000

4

4



Doubler

Location

Loc Qty

Loc Code

ST063

47

51789

47

D3506-3 Manufactured No

190 Each

87.0000

2

2



Doubler

Location

Loc Qty

Loc Code

ST063

87

51790

87

BB 11/07/21

BE 11/07/21  
B 7/22/21 x2

Dh  
11/07/20

BB 11/07/22

BB 11/07/22

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Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

MS20601-AD4W3 Purchased

No

190

Each

2,846.000

12

12



Rivet



12

BB 11/07/22

Location

Loc Qty

Loc Code

ST321

2846

114538

2846

ALS4-1032-225 Purchased

No

260

Each

730.0000

1

1



Insert



HL 11/07/25

Location

Loc Qty

Loc Code

ST282

730

110768

213

X1

117717

517

AN3C4A Purchased

No

260

Each

2,494.000

31

31



BOLT



HL 11/07/25

Location

Loc Qty

Loc Code

ST350

2494

117094

8

117313

2

117688

800

117795

500

117872

184

118012

500

118112

500

YBI

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, June 23, 2011 12:36:17 PM

Work Order ID: 71197

Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 6/23/2011



Required Date: 7/4/2011

Start Qty: 1.00



Required Qty: 1.00

AN3C5A	Purchased	No	260	Each	1,403.000	2	2
							22 11/09/25
Bolt							

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1396	
116419	28	
116549	54	
117343	500	
117508	14	
117764	300	
117872	500	

AN526C1032R10	Purchased	No	260	Each	245.0000	2	2
							22 11/07/25
Screw							

Location	Loc Qty	Loc Code
FP-B	107	
108062	107	
ST327	100	
114494	100	
ST328	38	
110049	38	

AN960C10L	NAS1149C0332	Purchased	No	260	Each	0.0000	33	33
	R						11-118306 (x33) 22 11/07/25	
washer								

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 23, 2011 12:36:17 PM

Page 5

Work Order ID: 71197

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

D2965 Manufactured No 260 Each 25.0000 1 1



Cap, 105 Skidtube



11/07/25

Location

Loc Qty

Loc Code

FP006

25

52057

25

X1

D2965-3 Manufactured No 260 Each 3.0000 1 1



Cap



11/07/25

Location

Loc Qty

Loc Code

FP005

3

50560

2

52282

1

B71300

X1

D3492-1 Manufactured No 260 Each 68.0000 4 4



Plug



11/07/25

Location

Loc Qty

Loc Code

FP

68

69531

8

69819

60

X1

D3492-3 Manufactured No 260 Each 60.0000 4 4



Plug



11/07/25

Location

Loc Qty

Loc Code

FP

60

69822

60

B70642

X1

D3492-7 Manufactured No 260 Each 0.0000 2 2



Plug



D3492-047

B28961

(X2) 11/07/25

Thursday, June 23, 2011 12:36:17 PM

Shop Packet Print

Page 5

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 23, 2011 12:36:17 PM

Work Order ID: 71197

Parent Item: D135-751-011



Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011



Start Qty: 1.00

Required Qty: 1.00

D3508-1	Manufactured	No	260	Each	12.0000	1	1
							<u>26</u> 1107125
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP016	12	
<u>61020</u>	12	<u>26</u>

D3508-3	Manufactured	No	260	Each	4.0000	1	1
							<u>26</u> 1107125
Wearplate							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	4	
38527	1	<u>1371210</u>
67489	3	<u>26</u>

D3508-5	Manufactured	No	260	Each	6.0000	1	1
							<u>26</u> 1107125
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	6	
<u>67160</u>	6	<u>26</u>

D3508-7	Manufactured	No	260	Each	11.0000	1	1
							<u>26</u> 1107125
Wearplate							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP021	11	
67159	5	
<u>67739</u>	6	<u>26</u>

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 23, 2011 12:36:17 PM

Page 7

Work Order ID: 71197

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

D3558-1 Manufactured No 260 Each 12.0000 1 1



Gasket



u107125

Location

Loc Qty

Loc Code

FP014

12

42533

1

50925

11

D3558-3 Manufactured No 260 Each 6.0000 1 1



Gasket



u107125

Location

Loc Qty

Loc Code

FP014

6

67486

6

1371651

xl

D3558-5 Manufactured No 260 Each 14.0000 1 1



Gasket



u107126

Location

Loc Qty

Loc Code

FP014

14

43244

1

50926

1

67485

12

xl

D3558-7 Manufactured No 260 Each 16.0000 1 1



Gasket



u107126

Location

Loc Qty

Loc Code

FP014

16

67162

16

xl

Thursday, June 23, 2011 12:36:17 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, June 23, 2011 12:36:17 PM

Work Order ID: 71197

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-007 Purchased No 260 Each 294.0000 2 2



O-RING



*Handwritten: 11/07/26*

Location

Loc Qty

Loc Code

FP-A

294

103697

294

NAS1611-010 Purchased No 260 Each 214.0000 4 4



O-RING



*Handwritten: x2*

4

*Handwritten: 11/07/26*

Location

Loc Qty

Loc Code

FP

96

117460

16

118077

80

FP-A

118

110915

95

115589

23

*Handwritten: x4*

NAS1611-013 Purchased No 260 Each 192.0000 4 4



O-RING



*Handwritten: 11/07/26*

Location

Loc Qty

Loc Code

FP

187

117291

47

117887

140

FP-A

5

116582

5

*Handwritten: x4*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 23, 2011 12:36:17 PM

Page 9

Work Order ID: 71197

Parent Item: D135-751-011

Parent Item Name: Skidtube Installation

Start Date: 6/23/2011

Required Date: 7/4/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

280

Each

2,494.000

8

8

BOLT

Location

Loc Qty

Loc Code

ST350

2494

117094

8

117313

2

117688

800

117795

500

117872

184

118012

500

118112

500

AN960C10L

NAS1149C0332  
R

Purchased

No

280

Each

0.0000

8

8

washer

D3512-1

Manufactured

No

280

Each

4.0000

2

2

Wearplate

Location

Loc Qty

Loc Code

ST500

4

70863

4

Thursday, June 23, 2011 12:36:18 PM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

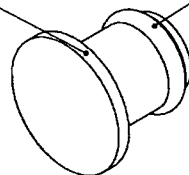
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

D3492-XX PLUG  
(SEE TABLE)

NAS1611 O-RING  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

#### NOTES:

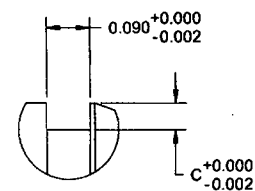
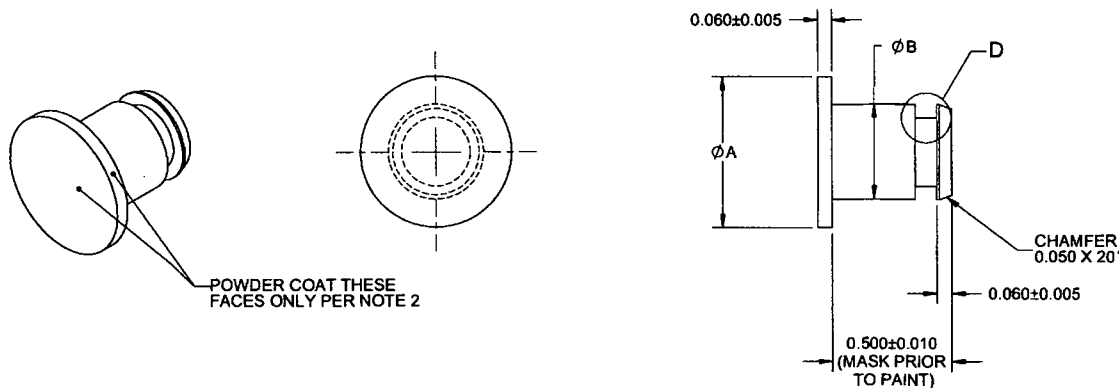
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71197  
*Cal/06/23*

RELEASED  
2011-05-30  
*W*

D	INCORPORATED DEO D3492-C-1. SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047, UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>JE</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AD</i>	D3492	SHEET 1 OF 2
APPROVED	<i>AD</i>	TITLE	SCALE
DE APPR.	<i>AD</i>	PLUG	2:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



**DETAIL D**

**D3492-XX PLUG**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC	
D3492-1	0.625	0.394	0.050	M6061T6R0.625	△D
D3492-3	0.750	0.582	0.045	M6061T6R0.750	
D3492-5	0.375	0.188	0.045	M6061T6R0.375	
D3492-7	0.500	0.270	0.045	M6061T6R0.500	
D3492-9	0.938	0.750	0.045	M6061T6R1.000	
D3492-11	0.850	0.664	0.045	M6061T6R0.875	
D3492-13	0.750	0.510	0.045	M6061T6R0.750	△D

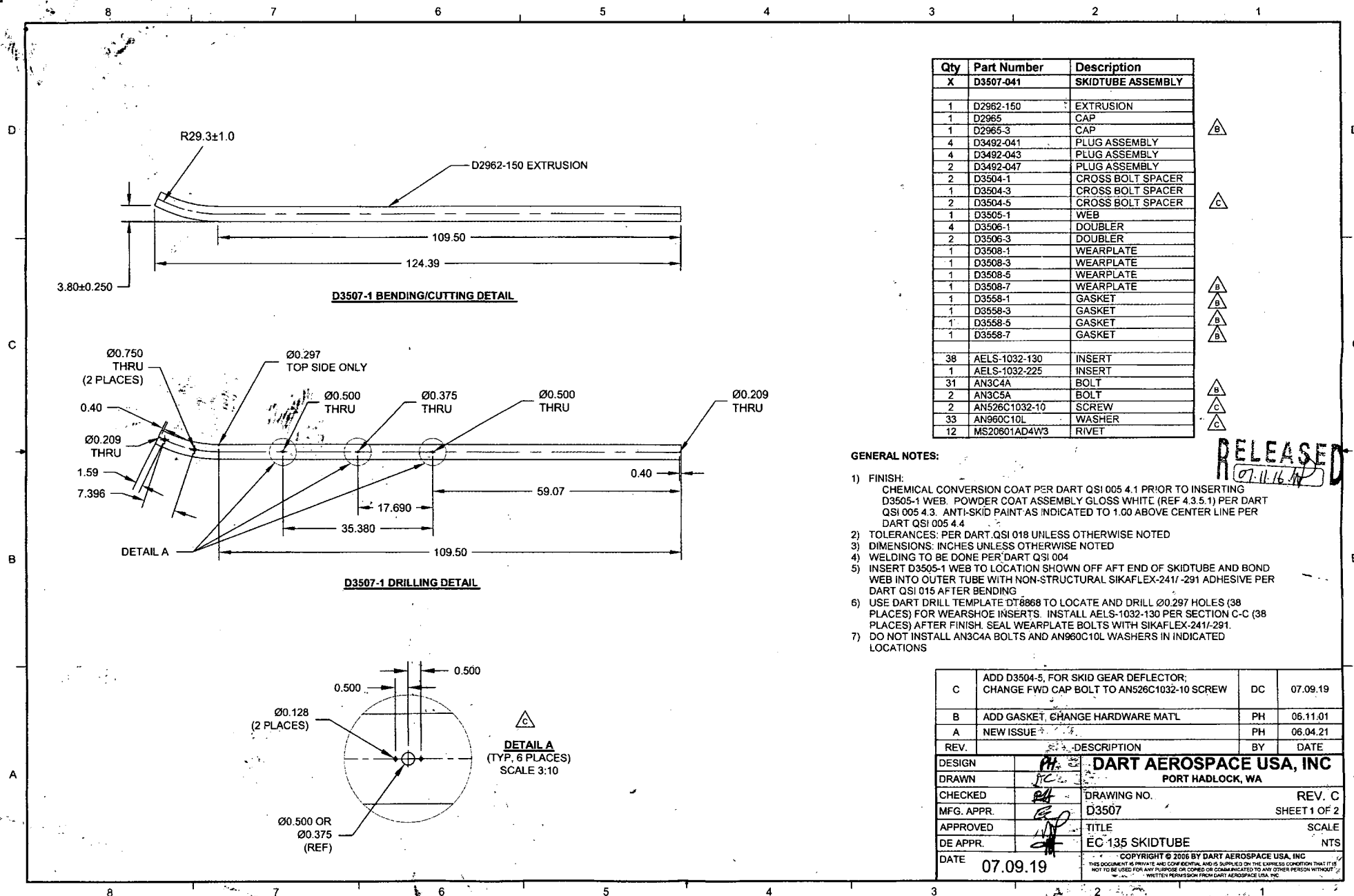
- NOTES:**
- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

**RELEASED**  
2011-05-30

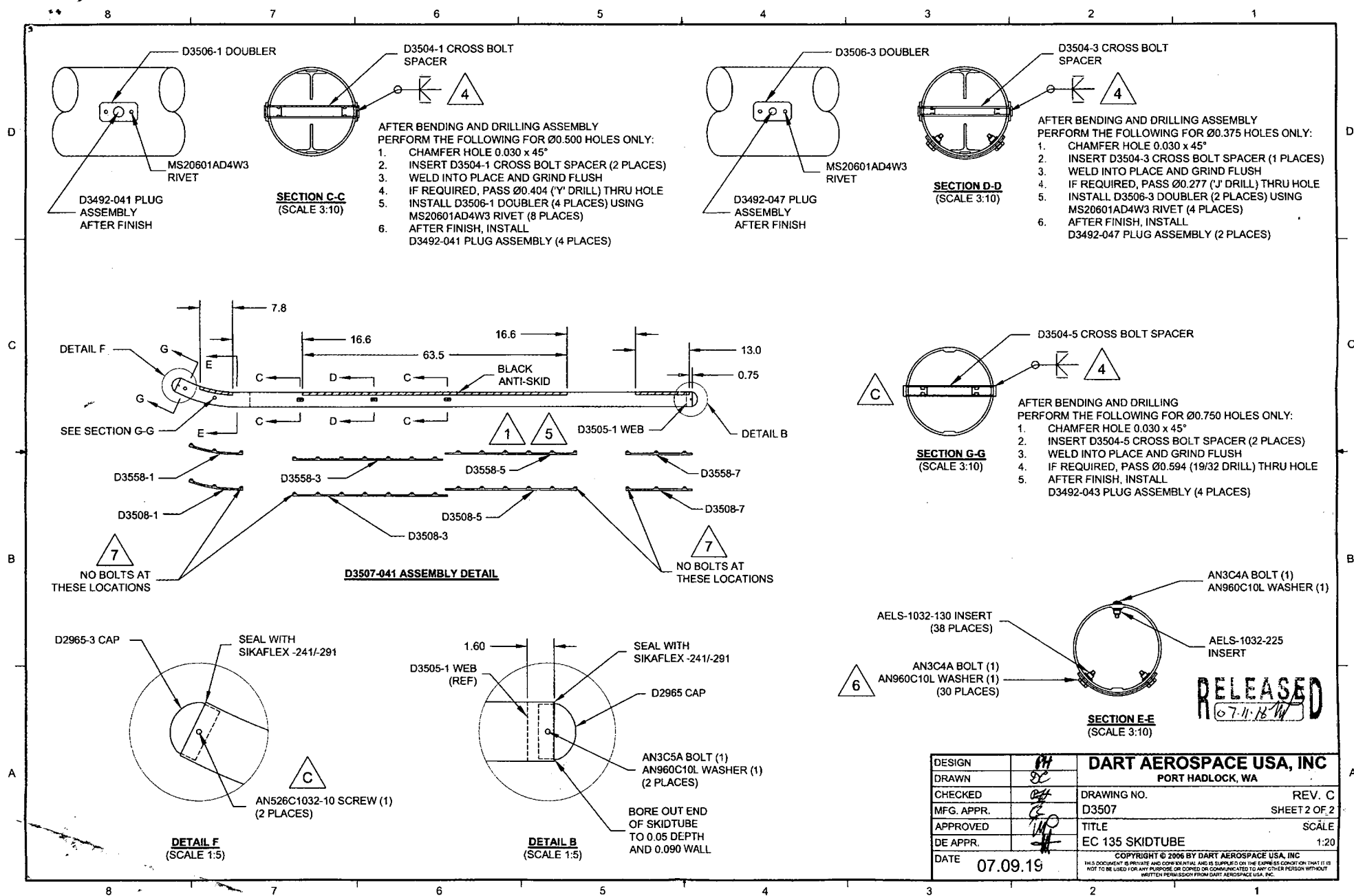
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	JFS	<b>D3492</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>PLUG</b>	4:1
DATE	11.05.24	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1









DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	024	DRAWING NO.	REV. C
MFG. APPR.	02	D3507	SHEET 2 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	EC 135 SKIDTUBE	1:20
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC	
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